

Monday, November 30, 2015 11:44:44 AM

Page 2

NS1

NS2

Customer:

NR1

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.
Stamp

DAS
14
9-89

15/12/17

10:00
32
10:30

12 ϕ 15-12-17

DAS
34
9-89

0.00

(12) 15-12-17

DAS
9
9-89

Work Order ID 139485

139485

Page 3

Monday, November 30, 2015 11:44:44 AM

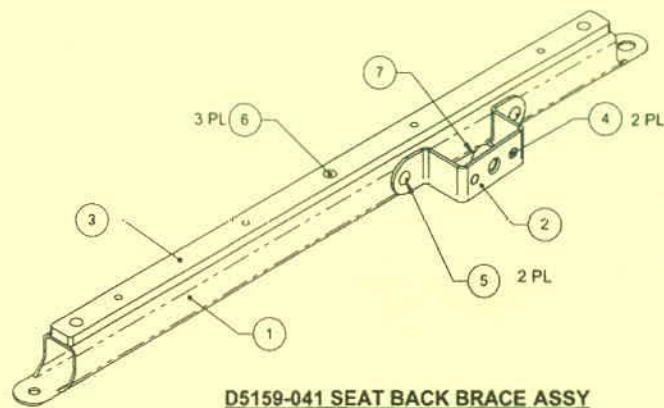
Item ID: D5159-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib
 Start Date: 11/30/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/30/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>J-506</u>	0.00				12			DEC 2 1 2015
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							
Quality Control									

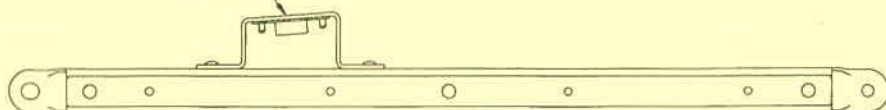
SA 20151223

ITEM	QTY	P/N	DESCRIPTION
	X	D5159-041	SEAT BACK BRACE ASSY
1	1	D5159-1	RIB
2	1	D5160-1	SEAT BRACE BRACKET
3	1	D5160-5	SHIM
4	2	MS20426AD3-4	RIVET, SOLID, CSK
5	2	MS20600M4W3	RIVET, BLIND (MONEL)
6	3	MS20601M4W4	RIVET, BLIND, CSK (MONEL)
7	1	MS21059L4	NUTPLATE



D5159-041 SEAT BACK BRACE ASSY

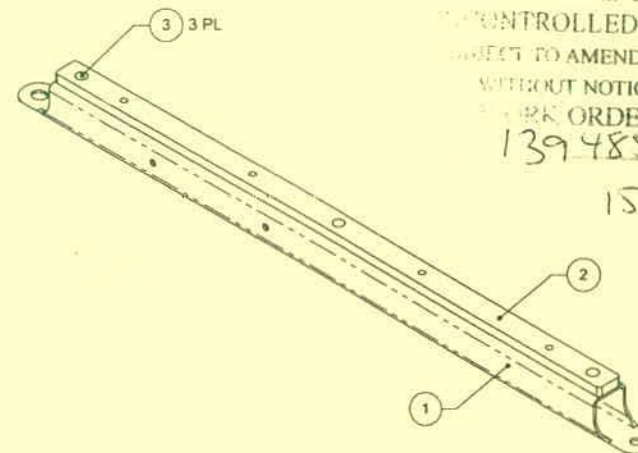
NOTE BRACKET
ANGLE



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5159-041" AND BATCH NUMBER BXXXXX
PER QSI 044, 6.1.
- 7) WEIGHT: 0.89 lbs

ITEM	QTY	P/N	DESCRIPTION
	X	D5159-043	SEAT BACK BRACE ASSY
1	1	D5159-1	RIB
2	1	D5160-5	SHIM
3	3	MS20601M4W4	RIVET, BLIND, CSK (MONEL)



D5159-043 SEAT BACK BRACE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5159-043" AND BATCH NUMBER BXXXXX
PER QSI 044, 6.1.
- 7) WEIGHT: 0.82 lbs

RELEASED

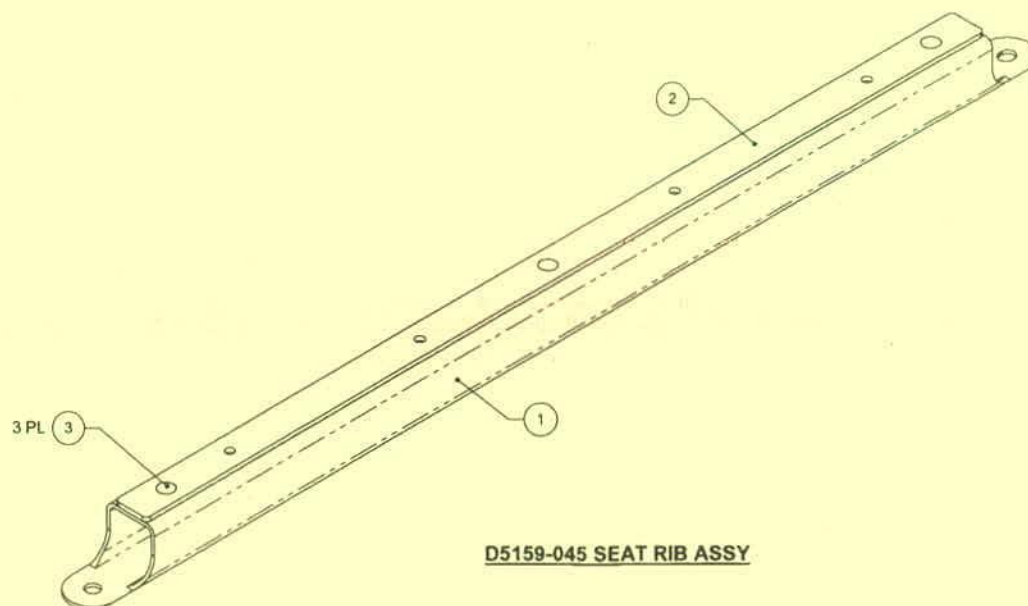
2015 FEB 04
Ecn 15-322 9

APPROVED

A	NEW ISSUE	AJS	14.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5159	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SEAT BRACE ASSY	NTS
DATE	14.09.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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WORK ORDER
139485 NW
15-12-02

ITEM	QTY -045	P/N	DESCRIPTION
	X	D5159-045	SEAT RIB ASSY
1	1	D5159-3	SEAT RIB
2	1	D5160-3	SHIM
3	3	MS20601M4W4	RIVET, BLIND, CSK (MONEL)



D5159-045 SEAT RIB ASSY

RELEASED

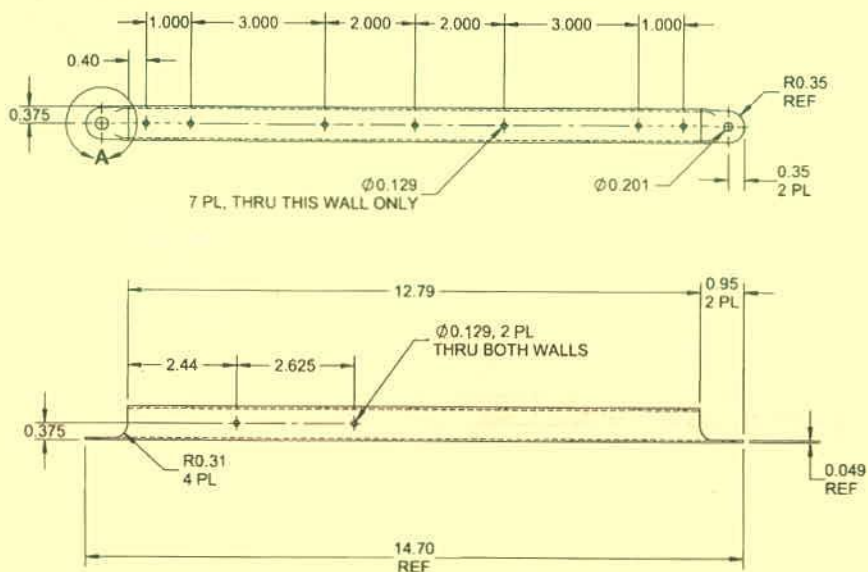
2015 FEB 04 *or*

NOTES:

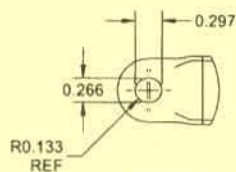
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5159-045" AND BATCH NUMBER BXXXXX
PER QSI 044, 6.1.
- 7) WEIGHT: 0.62 lbs

APPROVED

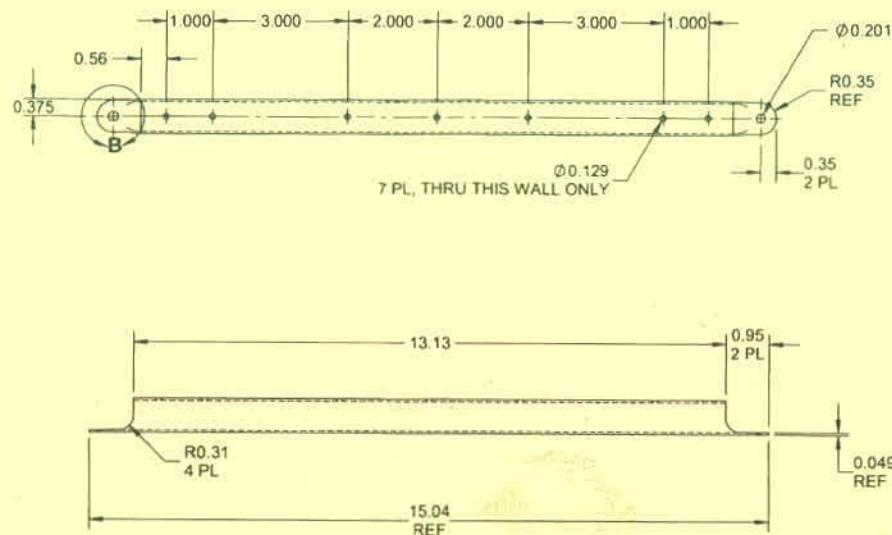
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5159	SHEET 2 OF 3
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DE APPR.	DS	SEAT BRACE ASSY	NTS
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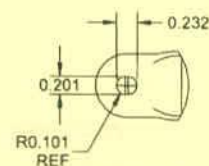
D5159-1 RIB



DETAIL A
SCALE 2X



D5159-3 SEAT RIB



DETAIL B
SCALE 2X

RELEASED

2015 FEB 04

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.6.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.49 lbs
-3: 0.50 lbs

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